Work Orde June-18-14 1:50		21227		*121	1227*							Page 1	
tem ID: Revision ID: tem Name:	D3462-041 Bracket		1	Accept	*N900	<u>)</u> 040	100)* ፡	Setup	Start Stop	171	S1* S2*	
	6/18/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:						"IXI	5 /"	
Approvals:		an: MLS		Tooling: SPC (Y/N):		Pate:		ŀ		Start Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr										1/1	
D3462	Rev	v C										14-0	9-
1 \\n Large Fab .arge Fab			\13.6 048 bbly as per dwg D3462	0.00				_6_		 .		0	JE
¹⁰ *11∩*		QC9- Inspect visual per (QSI004- Fusion Welds	0.00				6	,	10.9-	//	DAS 50 9-89	
QC Quality Control		Мето		0.00							7.63		
^{.20} *1ク ∩ *		QC5- Inspect part compl	leteness to step on W/O	0.00				<u> </u>	_\\4	. 0 9-l	٥	DAS 9	
QC		Memo		0.00								9-89	

Quality Control

DQA:			Date:						_				AG"	RT
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Vork Order uj	odate only	AERO	SPACE
						DISPOSITION					EPARTMENT			
Work Orde	er: .	 					. !			_	_		¬	
Part N	۱o. ِ					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineerir Quali	ity
NCR N	۱o. ِ					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Hec/Sto	re/Packaging Supplier	Oth	er 📙
Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspe	ector
Design Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator					,								1	
Offset/Setup			<u></u>											
Process							l					ļ		
Supplier														
Training	H		!						·					
Transport	\vdash						ł							
Unapproved			<u> </u>	<u> </u>		·	FΔI	UIT CA	TEGORY			<u> </u>		
Landi	nø (Gear		<u> </u>		General		oet on				·		
Larra		Bending			Г	Bend		Folio/F	Program	Г	Outside Dim	nensions	Pressure/For	rced
	\vdash	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
:		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature	e/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/L	Jnclear	Part Moved	·	Wrong Stock	(Pulled
	_	Crushing	.16		′	Countersink	Г	Misali	gned/off center	. [Positioned \	N rong	<u> </u>	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss,	/Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d			·		
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tul	oe		Fit/Function		Out of	Sequence		<u> </u>			

Work Order ID 121227 *121227* Page 2 June-18-14 1:56:11 PM Item ID: D3462-041 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Bracket Start Qty: 6.00 *6* **Start Date:** 6/18/14 **Cust Item ID:** Required Date: 6/18/14 **Reg'd Oty:** 6.00 *6* **Customer:** Reference: Run Process Plan: **Tooling:** Date: **Approvals:** Date: Stop QC: Date: Date: SPC (Y/N): Plan Reject Sequence ID/ **Operation** Set Up/ Tool ID Tool# Reject Insp. Accept **Work Center ID Description** Qty Qty Number Stamp **Run Hours** Code White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 130 0.00 6 \$ 14-9-17. 35% *130* Powdercoat 0.00 DYEN TEMPERATURE: Powder Coating 140 QC3- Inspect Part Finish 0.00 6 8 D 14/0 *140* QC 0.00 Memo Quality Control

150

Identify as per dwg & Stock Location: 5754/ 0.00

150

Packaging Packaging

Memo

0.00

6 7/6149-17

DQA:			Date:						•				"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er: .					DISFOSITION	. 1			A0AIII 51	., .,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
Part N	۱o.				:	Rework Scrap			Skid-tube Machining	Crosstube Small Fab	-4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	۱o. ِ					Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	ription of work order update	П	nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Design				· · · · ·									
Doc/Data													
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Handling/Pre						•					}		
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Landi	ng (Gear				General							
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unq	qualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	 ,
	Г	Heat Trea				Cut Too Short	Г	Mislab	-		Power Loss/	Surge	Other
		Inspectio		Tube		Drawing		Misrea					
		Marks/Cl	•			Drill Holes		Off-set					
,		Turning S				Finish		Out of	Calibration				
		Wave/Tw				Fit/Function		Out of	Sequence				

Work Ord <i>June-18-14 1:</i>		21227		*12						
Item ID: Revision ID:	D3462-041			Accept	*N900040100	*	Setup		17	S1 ³
Item Name:	Bracket							Stop	*N	S23
Start Date:	6/18/14	Start Qty: 6.00	*6*		Cust Item ID:					
Required Date	e: 6/18/14	Req'd Qty: 6.00	*6*		Customer:					
Reference:										
Approvals:	Process P	lan:	Date:	Tooling:	Date:		Run	Start	*N	R1
	QC:		Date:	SPC (Y/N):	Date:			Stop	*N	R2
Sequence ID/		Operation		Set Up/	Tool ID Tool # Plan	Accept	t Reje	ect	Reject	Insp.

Run Hours

0.00

0.00

Work Center ID

160

Quality Control

160

QC

Description

QC21- Final Inspection - Work Order Release

Memo

H4.Q-17

Number

Stamp

Qty

Code

Qty

Page 3

PQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
(A Closed:		Date:			WORK ORDER NON-	-00	JINFOI	NIVIAIVEE / OI		ork Order up	odate only	AEROSPACE		
Moule Ouda					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Work Orde	·				Rework	ì		Skid-tube	Crosstube	1	Water Jet	Engineering		
Part N	n				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	·				Use-as-is			noforming	Finishing	4	re/Packaging	Other		
NCR N	o				Suspected Unapproved			Large Fab	Composite]	Supplier			
Root		I	<u> </u>	Desc	ription of work order update	ᆜ	nitial	Act	ion	Sign &		T		
Cause	Date	Step	Qty	Desci	or non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector		
esign	Dute	Step	αι,	l	or non-comormance	<u> </u>	101 2118							
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Landi <u>n</u>	g Gear				General		•			-		7		
	Bending				Bend		Folio/F	rogram		Outside Dim	nensions	Pressure/Forced		
	Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	<u> </u>	Set-up		
	Cracks				Broken/Damage/Defect	<u></u>	Hardwa	re		Part Incorre	 	Temperature/Cure		
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	_	Weld		
	Cuffs			L	Contamination		-{	ions Incomplete/	Jnclear	Part Moved	L.—	Wrong Stock Pulled		
	Crushing				Countersink	$oxed{oxed}$	-1	ned/off center		Positioned \		¬		
	Heat Trea	at '		_	Cut Too Short	L_	Mislabe			Power Loss/	'Surge	Other		
Į	Inspectio	n Strip in	Tube		Drawing		Misrea	t						
	Marks/Ch	natter			Drill Holes		Off-set							
[Turning S	equence	!		Finish		Out of	Calibration						
	Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence						

June-18-14 1:56:15 PM

Work Order ID: 121227

121227

Parent Item:

D3462-041

D3462-041

Parent Item Name: Bracket

Start Date: 6/18/14

Required Date: 6/18/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

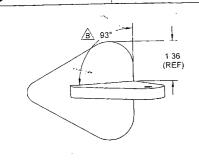
IPP REV. A 05.11.18 NEW ISSUE

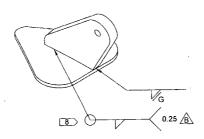
ecn 1049 EC verified by: DD esr rev B 08.07.15

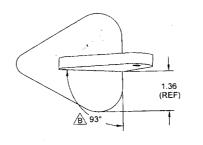
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	· .
D3462-1		Manufactured	No	ı		100	Each	10.0000	. , 1	6		A		-
D3462-1	•			f					**				14-	
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^{D3462-3} *D3462-3*	•	Manufactured	No			100	Each	19.0000	1 **	6	-		14-0	19-
Lug				Location		Loc		Loc Code					,	P
				WA002	100436		19 7			(F)	-			

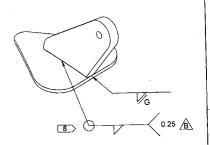
12

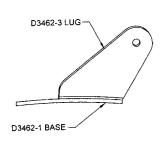
DQA: Date:					*DART								
QA Closed:			Date:			WORK ORDER NON	-C(NFOI		Wor	k Order up	date only	AEROSPACE
Work Orde	er:					DISPOSITION			³ AGAINST	DÊP	ARTMENT	PROCESS	
Part N	- ۔ ۱۰۰		· · · · · · · · · · · · · · · · · · ·	*		Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	ب .		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup												·	
Process Supplier Training Transport									·			· .	
Unapproved								UT CA	<u> </u>				
Landi	na G	COOR				General	FA	OLI CA	IEGORI		' 7.0		
Landi		Bending Centre No Cracks Crimp/Kii Cuffs				Bend BOM/Route Broken/Damage/Defect Burrs Contamination		Grain Hardwa Inspect	Program are ion Incomplete/Unqualified tions Incomplete/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved	tolerance	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled
<u>.</u>	-	Crushing Heat Trea	at į			Countersink Cut Too Short		Mislabe		-	Positioned V Power Loss/		Other
	$\overline{}$	Inspectio	-	Tube	-	Drawing		Misrea		_			· · · · · · · · · · · · · · · · · · ·
•	Ш	Marks/Ch			-	Drill Holes	_	Off-set			·	· · · · · · · · · · · · · · · · · · ·	
	Н		equence vist in Tub		-	Finish Fit/Function	\vdash	4	Calibration Sequence	-	<u> </u>	* * *	



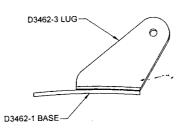














D3462-041 BRACKET ASSEMBLY

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER
NO 12127MCJ

14	О	6	_	18

17 41	-042	P/N	DESCRIPTION
_		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
	1	D3462-1	BASE
	1	D3462-3	LUG

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.75 lbs (TYP)
8) WELDING: PER DART QSI 004

D3462-042 BRACKET ASSEMBLY



С	SHOW	VIEWS OF D346	2-041 & D3462-042, UPDATE DWG N FACILITY	DC	07.10.24		
В		DIMENSIONS		RF	05.12.05		
	NEW IS			RF	05.09.20		
REV.	DESCR			BY	DATE		
DESIG		MP DC	DART AEROSPA HAWKESBURY, ONTAR	ACE L	T D		
CHECK		TIP -	DRAWING NO.		REV. C		
MFG.	APPR.	46 \0	D3462		SHEET 1 OF 2		
APPRO	OVED	100.	TITLE		SCALE		
DE AP	PR.	-#	BRACKET ASSEMBLY 12				
DATE		10.24	COPYRIGHT TO 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND OFFICENHAL AND IS EMPHUED OF THE EARNESS CONCLION THAT IT IS NOT TO BE USED FOR ANY PUBLIC OF COPIED OR COMMINIONATIOS TO ANY OTHER PERSON WITHOUT HOT TO BE USED FOR ANY PUBLIC OR COPIED OR COMMINIONATIOS TO ANY OTHER PERSON WITHOUT HOT TO BE USED FOR ANY PUBLIC OR COPIED OR COMMINIONATIOS TO ANY OTHER PERSON WITHOUT HOT TO BE USED FOR ANY PUBLIC OR COPIED OR COPIED OR COPIED AND ANY OTHER PERSON WITHOUT HOT TO BE USED FOR ANY PUBLIC OR COPIED				

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С

60° (TYP) 3.36 R0.82 (TYP) D3462-1F FLAT PATTERN

0.375 2.55 Ø0.257 (DRILL "F") 1.98 B - R20.0±0.1 R0.50 -0.08 X 45° CHAMFER-(TYP) D3462-3 LUG

R0.55

R20.0±0.1

D3462-1 BEND DETAIL (MAKE FROM D3462-1F)

NOTES:
1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S11GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.28 lbs

NOTES:
1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.47 lbs



DESIGN	7	DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHECKED	1. J. 1. 7.C.	DRAWING NO.	REV. C
MFG, APPR.	127X -	D3462	SHEET 2 OF 2
APPROVED	100.0	TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	1:1
D. T.	10.24	COPYRIGHT © 2005 BY DART AERO THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THIS NOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMUNICATED TO	E EXPRESS CONDITION THAT IT IS D ANY OTHER PERSON WITHOUT

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